



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4171-1
Job Sheet 173300



Part No: D4171-1

Job Qty: 20 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/27/18

Job Tracking No:

Created By: Linda Lacelle

Due Date: 3/12/18

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		3/10/18	0.00	0.00	Start Up Machining-2		<i>[Signature]</i> 18/04/15
100	Doosan	20 pcs		3/12/18	0.00	3.99	Doosan		<i>[Signature]</i> 18/04/15
140	QC	20 pcs		3/12/18	0.00	0.00	QC8		<i>[Signature]</i> 18/04/15
200	Packaging	20 pcs		3/12/18	0.00	0.00	Packaging3-2	57083	APR 17 2018 6
210	QC21-SA	20 Ea		3/12/18	0.00	0.00	QC21		9-89

Part Op
Descriptions: 100 - 1-Turn as per Dwg & Folio FA963

DAS
21
9-89

APR 17 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R1.000	303 Round Bar-4.00 303 R 1.250	1.6000 ft (.08 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R1.000	2	61	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing <i>0.753</i>	0.750Inches ± 0.010	0.760 0.740		
2	Bushing <i>0.542</i>	0.540Inches ± 0.010	0.550 0.530		
3	Bushing <i>0.207</i>	0.210Inches ± 0.010	0.220 0.200		
4	Bushing <i>0.150</i>	0.150Inches ± 0.010	0.160 0.140		
5	Bushing <i>0.304</i>	0.305Inches + 0.000 - 0.002	0.305 0.303	Diameter	
6	Bushing <i>0.015</i>	0.010Inches ± 0.010	0.020 0.000	Radius	
7	Bushing <i>0.060</i>	0.060Inches ± 0.010	0.070 0.050		
8	Bushing <i>0.400</i>	0.395Inches + 0.015 - 0.005	0.410 0.390		
9	Bushing <i>0.553</i>	0.563Inches + 0.002 - 0.015	0.565 0.548		
10	Bushing <i>0.880</i>	0.880Inches ± 0.030	0.910 0.850	Diameter	
11	Bushing <i>0.193</i>	0.191Inches + 0.005 - 0.001	0.196 0.190	Diameter	
12	Bushing <i>0.063</i>	0.063Inches ± 0.010	0.073 0.053	Radius	
13	Bushing <i>0.060</i>	0.060Inches ± 0.010	0.070 0.050	Radius	
14	Bushing <i>45°</i>	45.000Degrees ± 0.500	45.500 44.500	Angle	
15	Bushing <i>0.023</i>	0.023Inches + 0.030 - 0.010	0.053 0.013		
16	Bushing <i>0.026</i>	0.030Inches ± 0.010	0.040 0.020		
17	Bushing <i>20°</i>	20.000Degrees ± 0.500	20.500 19.500	Angle	

Plex 2/27/18 2:46 PM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

FAULT CATEGORY

re	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
'Defect	☐ Weld	☐ Part Incorrect
plete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Mislabeled	☐ Finish
plete/Unclear	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence

Dart Aerospace Ltd.
1270 Aberdeen Street
Windsor, ON N6A 1K7
CANADA
TEL : 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/15/18



Container No: S061056



Part: D4171 - 1

Job No: 173300

Serial No/Batch: S061056

Revision:
Inspector: